

Date: Monday, 2/27/2006 4:17:40 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25964
Estimate Number : 11139
P.O. Number : N/A
This Issue : 2/27/2006 S.O. No. : N/A
Prsht Rev : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : N/A
Written By : *SRE COMMENT Below*
Checked & Approved By : *RD 06.02.28*
Comment : Est A 04.06.09 New issue - KJ/RF

Drawing Name : BRACKET
Part Number : D32051
Drawing Number : D3205 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 3/20/2006 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M7075T73B2500X0325

7075-T73 Bar 2.5 x 3.25"



Comment: Qty.: 0.3828 f(s)/Unit Total : 3.8283 f(s)

7075-T73 Bar 2.5 x 3.25"

Material: 7075-T73 (QQ-A-200/11 or QQ-A-250/12) or 2024-T3 (QQ-A-200/3 or QQ-A-250/4)

(M7075T73B2.500x03.25)

Identify for D3205-1

Batch: *M17646**u Dec 03 13*

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3205-1 as per Folio FA346 and Dwg D3205

Identify as D3205-1

Deburr and Tumble

15L 06.03.05 10

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

15L 06.03.05 10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06.03.05 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.03.05	3	- 3 parts scrap - 2 dimension - 250 is under tolerance. Machined cracked. - 1 part lifted while machining	AB 06.03.05	- scrap + replace	JL 06.03.05	2 06.03.06	AB 06.03.06	06.03.06

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:17:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25964

Part Number: D32051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/03/06

10

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the thread hole for D3205-1 before powder coat.

QIM 06-03-09

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA

06/03/09

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 414

6/3/13

(10)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/14

Job Completion



W 06/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25964
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**





 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.101	✓			
0.250	+/-0.010	.250	✓			
R0.37	+/-0.030	.37	✓			
0.125	+/-0.010	.129	✓			
0.250	+/-0.010	.253	✓			
2.380	+/-0.010	2.385	✓			
1.380	+/-0.005	1.380	✓			
0.500	+/-0.005	.501	✓			
0.880	+/-0.010	.880	✓			
Ø0.470 x 100°	+0.005/-0.000	.470	✓			
0.440	+/-0.005	.438	✓			
0.600	+/-0.005	.600	✓			
1/4-28UNF-313	N/A	1/4-28	✓			
0.250	+/-0.010	.255	✓			
Ø0.257	+0.005/-0.000	.258	✓			
1.750	+/-0.010	1.751	✓			
0.870	+/-0.005	.870	✓			
0.440	+/-0.005	.440	✓			
R0.25	+/-0.030	.250	✓			

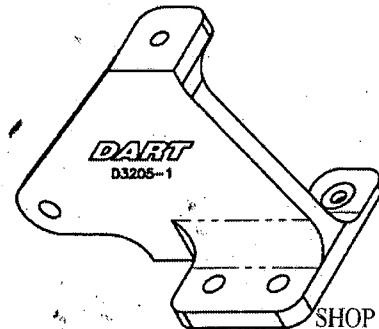
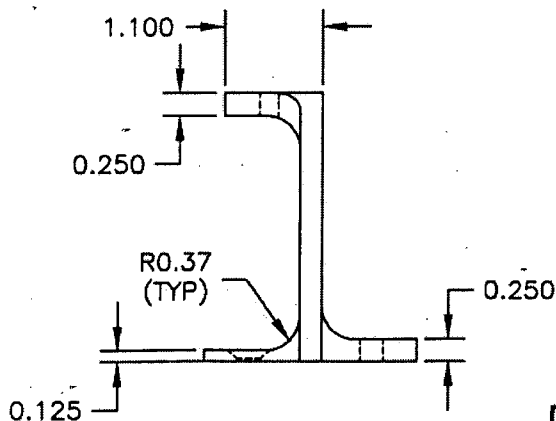
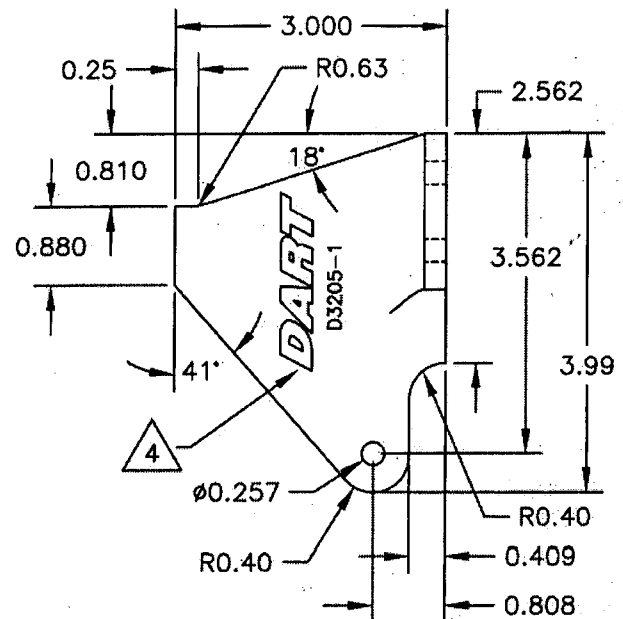
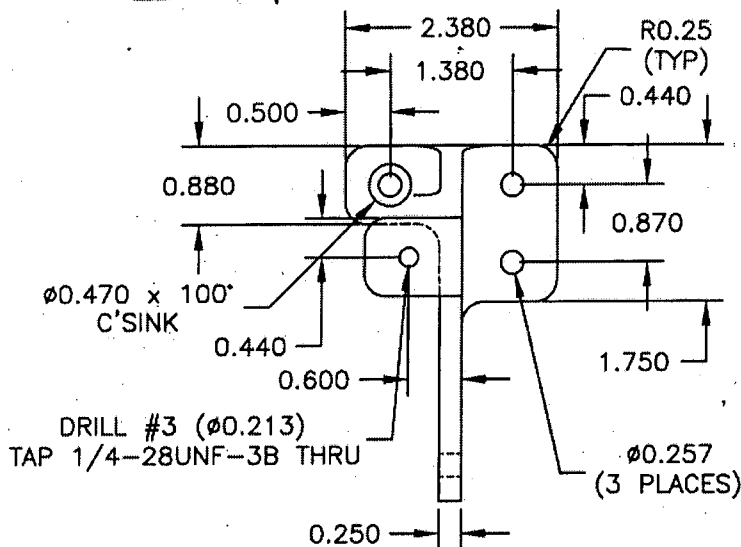
Measured by: J.L	Audited by: MS	Prototype Approval: N/A
Date: 06.03.04	Date: 06/03/04	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	



DESIGN 	DRAWN BY 	DART AEROSPACE HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3205	SHEET 1 OF
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 #



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
4) ENGRAVE DART P/N & LOGO AS SHOWN
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE INCHES

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WORK ORDER
NO. 25964

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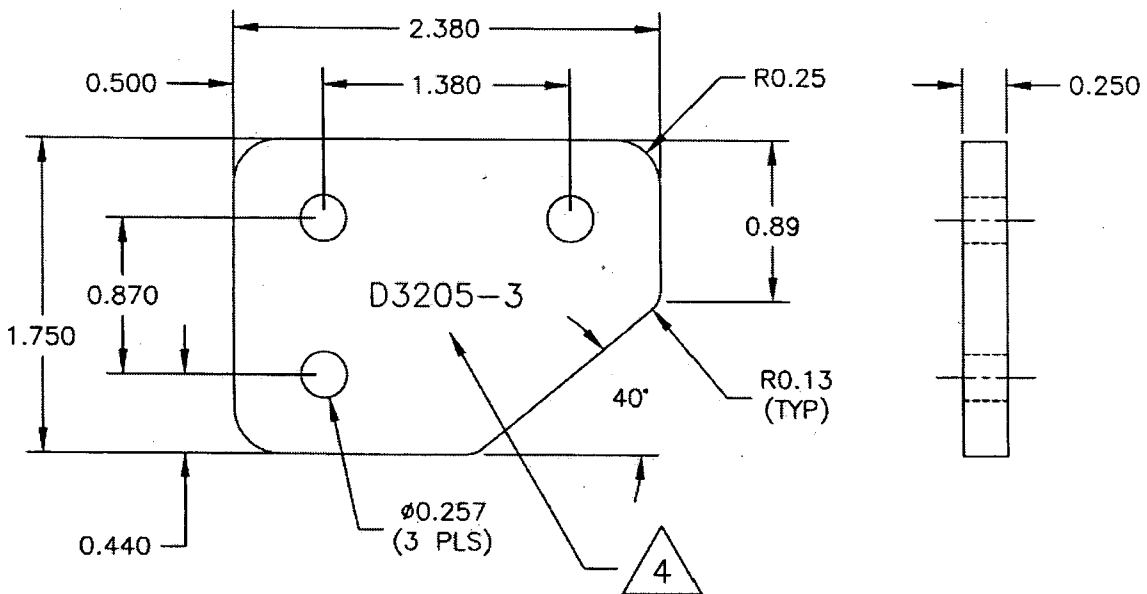
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DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
14	14	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
14	14	D3205
DATE	TITLE	REV. A
04.01.27	BRACKET	SHEET 2 OF 2
		SCALE
		1:1

RELEASED
04.04.05



D3205-3 BACK PLATE

NOTES:
BREAK ALL SHARP EDGES 0.005 TO 0.015
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
ENGRAVE DART P/N AS SHOWN
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE INCHES

WORK ORDER NO. 25964

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